



Dart Hawkesbury  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D4635-143**  
**Job Sheet 167106-G**



Part No: D4635-143

Job Qty: 1 ea

Part Name: Aft Ceiling Replacement Panel Assembly, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |                |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|----------------|
|       |                    |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time      |
| 90    | Start up Operation | 1 Ea  |            | 11/9/17  | 0.00      | 0.00    | Start Up Small Fab    | D.M.L 17-12-28 |
| 100   | Small Fab          | 1 pcs |            | 11/9/17  | 0.00      | 0.68    | Small Fab             | D.M.L 17-12-28 |
| 110   | Small Fab          | 1 pcs |            | 11/10/17 | 0.00      | 0.68    | Small Fab             | D.M.L 17-12-28 |
| 120   | QC                 | 1 pcs |            | 11/10/17 | 0.00      | 0.00    | QC5                   | PD 17-12-28    |
| 130   | Packaging          | 1 pcs |            | 11/10/17 | 0.00      | 0.00    | Packaging3            |                |
| 140   | QC21-SA            | 1 Ea  |            | 11/10/17 | 0.00      | 0.00    | QC21                  |                |

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4635-143 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: \_\_\_\_\_ 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # \_\_\_\_\_ Expiry Date \_\_\_\_\_ 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: \_\_\_\_\_

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: \_\_\_\_\_

140 - QC21- Final Inspection - Work Order Release

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated | Std Qty |
|-----------------------|----------------|----------|-----------|-----------|---------|
| 90-Start up Operation | D4635-3        | 1        | 2         | 0         | 0       |
|                       | D4669-1        | 1        | 27        | 0         | 0       |
|                       | D4669-3        | 1        | 38        | 0         | 0       |
|                       | D4695-3        | 1        | 5         | 0         | 0       |
|                       | D4732-1        | 1        | 6         | 0         | 0       |
|                       | D4732-13       | 1        | 6         | 0         | 0       |
|                       | D4732-37       | 1        | 3         | 0         | 0       |
|                       | D5022-3        | 1        | 1         | 0         | 0       |

### Part Specifications

Specifications could not be found.

Plex 10/24/17 12:52 PM dart.poulin.mario

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

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| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br><br>Suspected <input type="checkbox"/> | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/><br/>           Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Quality <input type="checkbox"/><br/>           Other <input type="checkbox"/> </div> </div> |                          |             |                          |      |                          |        |                          |      |                          |          |                          |       |                          |               |                          |        |                          |              |                          |         |                          |          |                          |                 |                          |                    |                          |                  |                          |                  |                          |         |                          |     |                          |                     |                          |            |                          |                     |                          |                  |                          |                       |                          |               |                          |          |                          |                          |                        |                          |       |                          |          |                          |            |                          |                    |                          |               |                          |           |                          |                      |                          |                                   |                          |               |                          |             |                          |               |                          |                                 |                          |             |                          |                  |                          |               |                          |       |                          |      |                          |                    |                          |                 |                          |         |                          |            |                          |              |                          |                       |                          |                  |                          |                    |                          |                      |                          |                |                          |                   |                          |            |                          |         |                          |        |                          |         |                          |                  |
| Date : _____<br><br><div style="border: 2px solid black; padding: 5px; transform: rotate(-15deg); display: inline-block;"> <b>Start up Operation</b><br/> <b>Mfg Date: 12/22/17</b><br/> <b>Job No: 167106-G</b> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                             | <div style="border: 2px solid black; padding: 5px; transform: rotate(-15deg); display: inline-block;"> <b>PART NO:</b><br/> <b>Revision:</b><br/> <b>Operation:</b><br/> <b>Change No:</b> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                          |             |                          |      |                          |        |                          |      |                          |          |                          |       |                          |               |                          |        |                          |              |                          |         |                          |          |                          |                 |                          |                    |                          |                  |                          |                  |                          |         |                          |     |                          |                     |                          |            |                          |                     |                          |                  |                          |                       |                          |               |                          |          |                          |                          |                        |                          |       |                          |          |                          |            |                          |                    |                          |               |                          |           |                          |                      |                          |                                   |                          |               |                          |             |                          |               |                          |                                 |                          |             |                          |                  |                          |               |                          |       |                          |      |                          |                    |                          |                 |                          |         |                          |            |                          |              |                          |                       |                          |                  |                          |                    |                          |                      |                          |                |                          |                   |                          |            |                          |         |                          |        |                          |         |                          |                  |
| <div style="transform: rotate(-15deg);"> <b>D4635 - 143</b><br/> <b>Start up Operation</b><br/> <b>Mfg Date: 12/22/17</b><br/> <b>Job No: 167106-G</b> </div> <div style="transform: rotate(-15deg);"> <b>PART NO:</b><br/> <b>Revision:</b><br/> <b>Operation:</b><br/> <b>Change No:</b> </div> <div style="transform: rotate(-15deg);"> <b>Start up Operation</b><br/> <b>Mfg Date: 12/22/17</b><br/> <b>Job No: 167106-G</b> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                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                                                                                                                                                                      | <b>MRB (QS1042) Approval</b><br><br>Completed By _____<br><br>Lead hand / Supervisor Approval Verification _____<br><br>QC / QA Coordinator Approval _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                          |             |                          |      |                          |        |                          |      |                          |          |  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| <div style="display: flex; justify-content: space-around; align-items: center;"> <div style="text-align: right;"> <b>S026668</b><br/> <b>AEROSPACE</b><br/> <b>DART</b> </div> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  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| <div style="display: flex;"> <div style="width: 30%;"> <b>Root Cause</b><br/> <table border="0"> <tr><td>Environment</td><td><input type="checkbox"/></td><td>No I</td><td><input type="checkbox"/></td></tr> <tr><td>Design</td><td><input type="checkbox"/></td><td>Oper</td><td><input type="checkbox"/></td></tr> <tr><td>Doc/Data</td><td><input type="checkbox"/></td><td>Offse</td><td><input type="checkbox"/></td></tr> <tr><td>Equip/Tooling</td><td><input type="checkbox"/></td><td>Suppli</td><td><input type="checkbox"/></td></tr> <tr><td>Handling/Pre</td><td><input type="checkbox"/></td><td>Trainin</td><td><input type="checkbox"/></td></tr> <tr><td>Material</td><td><input type="checkbox"/></td><td>Use for Testing</td><td><input type="checkbox"/></td></tr> <tr><td>Internal Transport</td><td><input type="checkbox"/></td><td>Poor Information</td><td><input type="checkbox"/></td></tr> <tr><td>Tribal Knowledge</td><td><input type="checkbox"/></td><td>Rushing</td><td><input type="checkbox"/></td></tr> <tr><td>LOA</td><td><input type="checkbox"/></td><td>Product Improvement</td><td><input type="checkbox"/></td></tr> <tr><td>Substation</td><td><input type="checkbox"/></td><td>Process Improvement</td><td><input type="checkbox"/></td></tr> <tr><td>Past Expiry Date</td><td><input type="checkbox"/></td><td>Manufacturing Process</td><td><input type="checkbox"/></td></tr> <tr><td>Misidentified</td><td><input type="checkbox"/></td><td>Past Due</td><td><input type="checkbox"/></td></tr> </table> </div> <div style="width: 40%;"> <table border="0"> <tr><td><input type="checkbox"/></td><td>Crimp/Kink/Ripple/Wave</td></tr> <tr><td><input type="checkbox"/></td><td>Cuffs</td></tr> <tr><td><input type="checkbox"/></td><td>Crushing</td></tr> <tr><td><input type="checkbox"/></td><td>Heat Treat</td></tr> <tr><td><input type="checkbox"/></td><td>Wave/Twist in Tube</td></tr> <tr><td><input type="checkbox"/></td><td>Marks/Chatter</td></tr> </table> </div> <div style="width: 30%;"> <table border="0"> <tr><td><input type="checkbox"/></td><td>BOM/Route</td></tr> <tr><td><input type="checkbox"/></td><td>Broken/Damage/Defect</td></tr> <tr><td><input type="checkbox"/></td><td>Inspection Incomplete/Unqualified</td></tr> <tr><td><input type="checkbox"/></td><td>Contamination</td></tr> <tr><td><input type="checkbox"/></td><td>Countersink</td></tr> <tr><td><input type="checkbox"/></td><td>Cut Too Short</td></tr> <tr><td><input type="checkbox"/></td><td>Instructions Incomplete/Unclear</td></tr> <tr><td><input type="checkbox"/></td><td>Drill Holes</td></tr> </table> </div> <div style="width: 30%;"> <table border="0"> <tr><td><input type="checkbox"/></td><td>Power Loss/Surge</td></tr> <tr><td><input type="checkbox"/></td><td>Folio/Program</td></tr> <tr><td><input type="checkbox"/></td><td>Grain</td></tr> <tr><td><input type="checkbox"/></td><td>Weld</td></tr> <tr><td><input type="checkbox"/></td><td>Wrong Stock Pulled</td></tr> <tr><td><input type="checkbox"/></td><td>Out of Sequence</td></tr> <tr><td><input type="checkbox"/></td><td>Off-set</td></tr> <tr><td><input type="checkbox"/></td><td>Mislabeled</td></tr> <tr><td><input type="checkbox"/></td><td>Fit/Function</td></tr> <tr><td><input type="checkbox"/></td><td>Misaligned/off center</td></tr> </table> </div> <div style="width: 30%;"> <table border="0"> <tr><td><input type="checkbox"/></td><td>Positioned Wrong</td></tr> <tr><td><input type="checkbox"/></td><td>Outside Dimensions</td></tr> <tr><td><input type="checkbox"/></td><td>Over/Under tolerance</td></tr> <tr><td><input type="checkbox"/></td><td>Part Incorrect</td></tr> <tr><td><input type="checkbox"/></td><td>Part Lost/Missing</td></tr> <tr><td><input type="checkbox"/></td><td>Part Moved</td></tr> <tr><td><input type="checkbox"/></td><td>Drawing</td></tr> <tr><td><input type="checkbox"/></td><td>Finish</td></tr> <tr><td><input type="checkbox"/></td><td>Misread</td></tr> <tr><td><input type="checkbox"/></td><td>Turning Sequence</td></tr> </table> </div> </div> |                                                                                                                                                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                          | Environment | <input type="checkbox"/> | No I | <input type="checkbox"/> | Design | <input type="checkbox"/> | Oper | <input type="checkbox"/> | Doc/Data | <input type="checkbox"/> | Offse | <input type="checkbox"/> | Equip/Tooling | <input type="checkbox"/> | Suppli | <input type="checkbox"/> | Handling/Pre | <input type="checkbox"/> | Trainin | <input type="checkbox"/> | Material | <input type="checkbox"/> | Use for Testing | <input type="checkbox"/> | Internal Transport | <input type="checkbox"/> | Poor Information | <input type="checkbox"/> | Tribal Knowledge | <input type="checkbox"/> | Rushing | <input type="checkbox"/> | LOA | <input type="checkbox"/> | Product Improvement | <input type="checkbox"/> | Substation | <input type="checkbox"/> | Process Improvement | <input type="checkbox"/> | Past Expiry Date | <input type="checkbox"/> | Manufacturing Process | <input type="checkbox"/> | Misidentified | <input type="checkbox"/> | Past Due | <input type="checkbox"/> | <input type="checkbox"/> | Crimp/Kink/Ripple/Wave | <input type="checkbox"/> | Cuffs | <input type="checkbox"/> | Crushing | <input type="checkbox"/> | Heat Treat | <input type="checkbox"/> | Wave/Twist in Tube | <input type="checkbox"/> | Marks/Chatter | <input type="checkbox"/> | BOM/Route | <input type="checkbox"/> | Broken/Damage/Defect | <input type="checkbox"/> | Inspection Incomplete/Unqualified | <input type="checkbox"/> | Contamination | <input type="checkbox"/> | Countersink | <input type="checkbox"/> | Cut Too Short | <input type="checkbox"/> | Instructions Incomplete/Unclear | <input type="checkbox"/> | Drill Holes | <input type="checkbox"/> | Power Loss/Surge | <input type="checkbox"/> | Folio/Program | <input type="checkbox"/> | Grain | <input type="checkbox"/> | Weld | <input type="checkbox"/> | Wrong Stock Pulled | <input type="checkbox"/> | Out of Sequence | <input type="checkbox"/> | Off-set | <input type="checkbox"/> | Mislabeled | <input type="checkbox"/> | Fit/Function | <input type="checkbox"/> | Misaligned/off center | <input type="checkbox"/> | Positioned Wrong | <input type="checkbox"/> | Outside Dimensions | <input type="checkbox"/> | Over/Under tolerance | <input type="checkbox"/> | Part Incorrect | <input type="checkbox"/> | Part Lost/Missing | <input type="checkbox"/> | Part Moved | <input type="checkbox"/> | Drawing | <input type="checkbox"/> | Finish | <input type="checkbox"/> | Misread | <input type="checkbox"/> | Turning Sequence |
| Environment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            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